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D212-664-207B
Job Sheet 183613



Part No: D212-664-207B

Job Qty: 1 ea

Part Name: Aft Crosstube - Low Standard



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 9/26/18

Created By: Jesse White

Type: SOLD

Description:

Note: D212-664-247 REV.D / IIN-D212-664 REV.J IPP REV:A 13.09.16 AS PER DWG REV.B DD VERF:JLM IPP
REV:B 14.02.12 AS PER DSI9680 REVA DD VERF:JLM

Ship Via:

Bill of Materials



Container No: S112705



Part: D212-664-207B

Job No: 183613

Serial No/Batch: S112705

Revision: D/J

Inspector:

Exp Date:

Instructions: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC

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Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/26/18	0.00	0.00	Start Up Crosstubes-2		AS SEP 20 2018
110	Packaging	1 pcs		9/26/18	0.00	0.00	Packaging1-3		NR
120	CNC Bend Crosstubes	1 pcs		9/26/18	0.00	2.50	CNC Bend Crosstube		
130	QC	1 pcs		9/26/18	0.00	0.00	QC15		
140	Crosstubes	1 pcs		9/26/18	0.00	2.55	Crosstubes-2		
150	HandFXtube	1 pcs		9/26/18	0.00	0.57	HandFinish5		
160	QC	1 pcs		9/26/18	0.00	0.00	QC5		
170	QC	1 pcs		9/26/18	0.00	0.00	QC7-1		
180	Outsource	1 pcs		9/26/18	0.00	0.00	Outsource2		
190	Packaging	1 pcs		9/26/18	0.00	0.00	Packaging2		
200	QC	1 pcs		9/26/18	0.00	0.00	QC5		✓
210	Crosstubes	1 pcs		9/26/18	0.00	2.55	Crosstubes-2		NR
220	SprayPaint	1 pcs		9/26/18	0.00	0.00	Spray Paint		AS SEP 20 2018
230	QC	1 pcs		9/26/18	0.00	0.00	QC14		
240	Crosstubes	1 pcs		9/26/18	0.00	2.55	Crosstubes-2		AS SEP 20 2018
250	QC	1 pcs		9/26/18	0.00	0.00	QC5		38
255	Packaging	1 pcs		9/26/18	0.00	0.00	Packaging1-3		9-89
260	QC	1 pcs		9/26/18	0.00	0.00	QC4		
270	Packaging	1 pcs		9/26/18	0.00	0.00	Packaging3-1		
275	DC	1 pcs		9/26/18	0.00	0.00	DC		MJS 18-09-24
280	QC21-FG	1 Ea		9/26/18	0.00	0.00	QC21		MJS 18-09-24

Part Op 120 - Bend tube as per Dwg D212-664-247 using CNC bender program and Folio FT

Descriptions: 140 - 1-Drill Rivet holes as per Dwg D212-664-247 using DT8972. 2-Drill pilot holes in tube as per Dwg D212-664-247 using DT8550 and DT8551 3-Ream hole to finish size in tube as per Dwg D212-664-247 4- *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-247 5-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-247

150 - ***IMMEDIATELY AFTER GRINDING*** 1- PRESSURE WASH X-TUBE INSIDE AND OUT 2- ALODINE AND ACID ETCH X-TUBE INSIDE AND OUT AS PER QSI005.

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

190 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D412-664-203

210 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Rivet Cuffs as per Dwg D212-664-247. with Sika flex in Between tube & Cuff A/R SIKAFLEX -241/-291 BATCH: _____

220 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside & outside cross tube as per QSI 005 4.2 BATCH: 138877 2- Apply matte clear coat to underside of cross tube per QSI005 4.2 BATCH: 138832 3- MASK UNDERSIDE OF CROSSTUBE AS SHOWN ON DWG BEFORE PAINTING 4 -Paint Outside of Tube as per Dart QSI 005 4.2 BATCH: 138949 5-Remove masking

230 - Wrap in plastic bag to protect from scratches ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

240 - *****LAY DOWN CROSSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP, USE HOLE IN TAPE MEASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** Assemble as per Dwg D212-664-247 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-247 and QSI 015 A/R Proseal 890 Batch: 5096394 EXP: 3/19 PROSEAL CURE TIME 72 HOURS: Start: 18-9-20 Finish: 18-9-23 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) as per Dwg D212-664-247. ***Torque all clamps to 80-100 IN-LBS.***

250 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.*** ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

260 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____

270 - Identify and pack for shipping as per PPP D212-664-207B

275 - Photocopy bluefile and create labels as per PPP D212-664-207B CHG004

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-207TRN	Crosstube Turning Detail	1 Ea (1 ea)	90-Start up Operation	S112518
CR3212-4-06	Rivet	44 Ea (44 ea)	210-Crosstubes	S112514
D3660-1	Cuff	2 Ea (2 ea)	210-Crosstubes	S112522
D3595-063-530	Rubber Cushion 0.63" Wide X 5.30" Long	4 Ea (4 ea)	240-Crosstubes	
D5018-1	Support, 214 Aft	2 Ea (2 ea)	240-Crosstubes	
MS21920-28	Clamp	4 Ea (4 ea)	240-Crosstubes	
AN6-40A	3/8-24 Bolt X 3" Long	4 Ea (4 ea)	255-Packaging	S112512
AN6-41A	Bolt	2 Ea (2 ea)	255-Packaging	S112513
D3428-1	Placard	1 Ea (1 ea)	255-Packaging	S112520
MS21042L6	Nut	6 Ea (6 ea)	255-Packaging	S112515
NAS1149D0663J	Washer	18 Ea (18 ea)	255-Packaging	S112519

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D212-664-207TRN	1	0	0
210-Crosstubes	CR3212-4-06	44	233	0
	D3660-1	2	14	0
240-Crosstubes	D3595-063-530 S080001	(4)	61	0
	D5018-1 F130699	(2)	10	0
	MS21920-28 S060057	(4) S037668	92	0
255-Packaging	AN6-40A	4	113	0
	AN6-41A	2	45	0
	D3428-1	1	27	0
	MS21042L6	6	452	0
	NAS1149D0663J	18	1,310	0

Part Specifications

Specifications could not be found.

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